

Date: Tuesday, 09/01/2007 1:08:04 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FITTING
 Job Number : 30147
 Estimate Number : 10416
 P.O. Number : N/A Part Number : D31981
 This Issue : 09/01/2007 S.O. No. : N/A Drawing Number : D3198 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : A
 Previous Run : 30147 Material : N/A
 Due Date : 16/01/2007 Qty: 20 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est: A 03.11.11 New Issue KJ/RF
 Est Rev:B Now on Waterjet 07-01-09 JLM

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S11GA	304/316 .125 Sheet
2.0	WATER JET	FLOW WATER JET
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
5.0	BRAKE NC	NC BRAKE



Comment: Qty.: 0.1103 sf(s)/Unit Total : 2.2050 sf(s)
 304/316 .125 Sheet
 Batch: M102817



Comment: FLOW WATER JET
 1-Cut as per Dwg D3198
 Dwg Rev: A
 Prog Rev: A

2-Deburr if necessary

SAD 07/01/15 (20)



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/01/15 (20)



Comment: SECOND CHECK

SA 07/01/15 (20)



Comment: NC BRAKE

1-Deburr if necessary
 2-Form as per Dwg D3198

SB 07/01/18 (20)

SB 07/01/16 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: Date: 07/01/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 09/01/2007 1:08:04 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 30147

Part Number: D31981

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/04/18 (20)

7.0

POWDER COATING

POWDER COATING



N/101601



(20x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M-R/48 07/01/18

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/04/18 (20)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: SH38

07/01/18 (20)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

07/01/19

Job Completion



C207101119

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/8/2007 10:49:57 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FITTING
Job Number	: 30147		
Estimate Number	: 10416		
P.O. Number	:	Part Number	: D31981
This Issue	: 1/8/2007	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3198 REV A
First Issue	: / /	Project Number	: N/A
Previous Run	: 25486	Drawing Revision	: A
	Type : PURCHASED PARTS	Material	:
Written By	: <u> </u>	Due Date	: 1/20/2007
Checked & Approved By	: <u> </u>	Qty:	20
Comment	: Est: A 03/11.11 New Issue KJ/RF	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

PG

PURCHASING

**Comment:** PURCHASING

Issue P/O: _____

Email or Ship DXF file to vendor

Laser Cut flat pattern per Dwg D3198

Material release note is required

12045.125
105 g.

[Signature]

2.0

D31981F

Fitting-Flat



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
 Fitting

3.0

PACKAGING 1

PACKAGING RESOURCE #1

**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

4.0

QC6

DIMENSIONAL CHECK

**Comment:** DIMENSIONAL CHECK

5.0

BRAKE NC

NC BRAKE

**Comment:** NC BRAKE

1-Deburr if necessary

2-Form as per Dwg D3198

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/8/2007 10:49:58 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 30147

Part Number: D31981

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

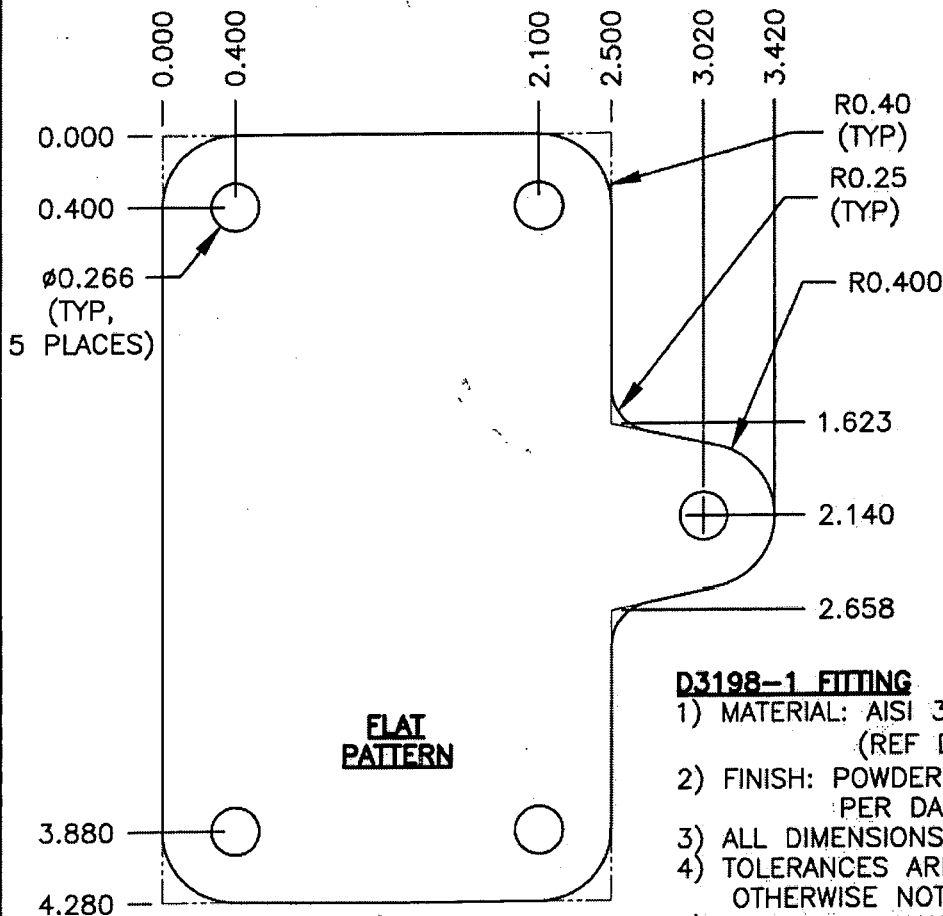
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



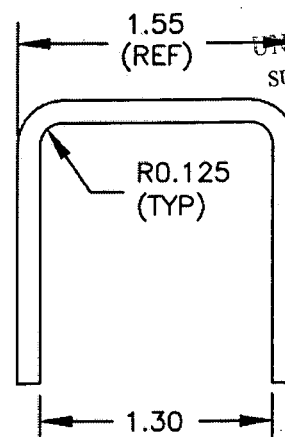
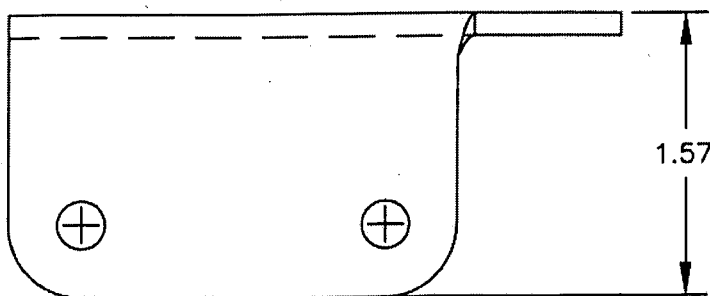
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3198	REV. A SHEET 1 OF 1
DATE 03.09.26		TITLE FITTING	SCALE 1:1
A	03.09.26	NEW ISSUE	



D3198-1 FITTING

- 1) MATERIAL: AISI 304/316 SS SHEET 0.125 THICK (REF DART SPEC. M304S11GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

RELEASED
03.10.10



UNCONTROLLED COPY
RETURN TO
ENGINEERING
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30147

**BEND
DETAIL**

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DART AEROSPACE LTD	Work Order:	30147
Description:	Part Number:	D3198 -1
Inspection Dwg:	Rev:	Page 1 of 1


FIRST ARTICLE INSPECTION CHECKLIST

X

x

[illegible]

Measured by:	SAD
Date:	07.01.15

Audited by:	
Date:	07/04/15

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	